

Work Order ID 160968

Friday, May 05, 2017 11:31:01 AM

160968

SCRAP

Page 1

Item ID: D3440-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp (Supersedes B67-43001-309)

Start Date: 5/8/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/15/2017 Req'd Qty: 5.00

5

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan:

Date: MAY 05 2017 Tooling:

Date:

Run Start

NR1

QC: DAS 21 9-09

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3440	B
-------	---

100

0.00

100

Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.950" long

6 0 K+ 17-05-08

110

0.16

110

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

1.40

HAAS CNC vertical machine #1

Machine as per Folio FA538 and Dwg D3440 Dwg Rev: B Identify as
D3440-3 Folio Rev: AA Debur

5 1 K+ 17-05-08

P.T.O.

120

0.00

120

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

5 0 K+ 17-05-08

DQA:

Date: 17-05-08

QA Closed: 

Date:

MAY 16 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>160 968</u> Part No. <u>D3440-3</u> NCR No. <u>17-6426</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER: ☐																																																																					

DQA:

Date: 2017-05-25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RPH Date: MAY 16 2017

Work Order update only ☐

Work Order: 160968 Part No. D3440-3 NCR No. 17-6427		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: 17-05-08		Step #: 110		QTY Effective: 5			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				PD 17-05-08	
.257" holes are .025" off centre R.C. operator LOA				Scrap + destroy no replace				Completed By KT 17-05-08 Lead hand / Supervisor Approval Verification DAS 20 9-89 17-05-08	
								QC / QA Coordinator Approval PD 17-05-08	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☒ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ ☒ Outside Dimensions Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER :							

Work Order ID 160968

Friday, May 05, 2017 11:31:01 AM

160968

Page 2

Item ID: D3440-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp (Supersedes B67-43001-309)
Start Date: 5/8/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 5/15/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				_____	_____	_____	_____
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 1.19				_____	_____	_____	_____
150 *150* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo START TIME: _____ OVEN TEMPERATURE: FINISH TIME: _____	0.00 0.35				_____	_____	_____	_____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Work Order ID 160968

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160968

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Start Date: 5/8/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 5/15/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				_____	_____	_____	_____
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				_____	_____	_____	_____
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				_____	_____	_____	_____


MAY 09 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Page 1

Friday, May 05, 2017 11:31:01 AM

Work Order ID: 160968

160968

Parent Item: D3440-3

D3440-3

Parent Item Name: Clamp (Supersedes B67-43001-309)

Start Date: 5/8/2017

Required Date: 5/15/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A05.07.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	12.6670	0.3292	1.732632			

M6061T6B1 250X01 250

**

6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT003

12.667

m135377

0.667

→ m136327

12

1.667
+0.334

Kt 17-05-08

DQA: _____ Date: _____

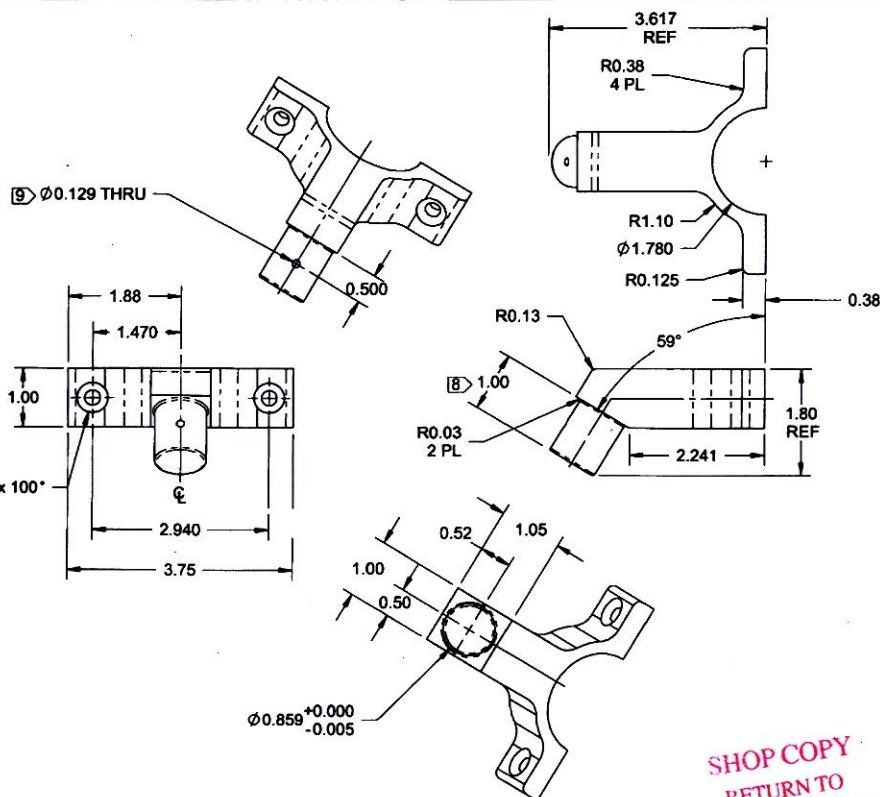


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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OTHER : ☐									

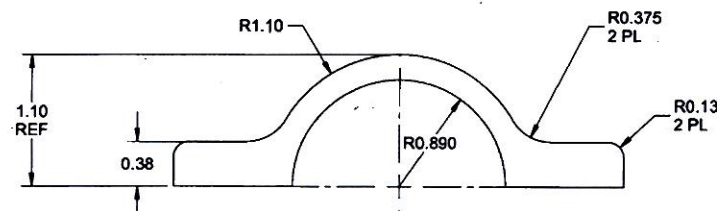
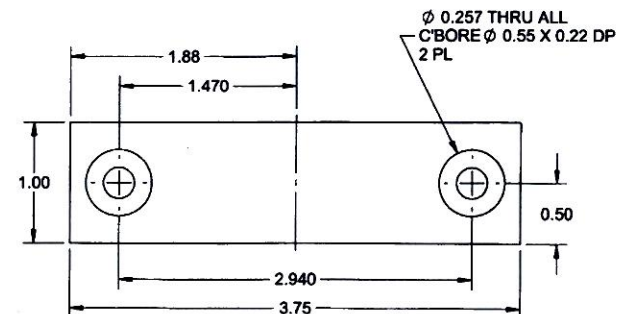


D3440-1 TUBE GUIDE
SUPERSEDES PREMIER P/N B67-43001-25/-307

D3440-1/-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ-A/200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D3440-X PER DART QSI 044 6.1
- 7) WEIGHT: D3440-1=0.35 lb
D3440-3=0.11 lb
- 8) MASK BEFORE PAINTING.
- 9) DRILL HOLE AT ASSEMBLY.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160968 MLJ
170FO5



D3440-3 CLAMP
SUPERSEDES PREMIER P/N B67-43001-309

RELEASED
2014-12-08

B	RE-FORMAT DWG TO CURRENT STANDARD, 90° WAS 93° (ZIN 84-2), 0.132 DEEP WAS 0.085 DEEP (ZIN C4-4) REASON/FACILITATE MANUFACTURING	DB	14.07.22
A	NEW ISSUE	MB	05.06.02
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.07.22		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3440

TITLE BLADE FOLD KIT PARTS

SCALE NTS

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